

Work Order ID 141495

Wednesday, March 09, 2016 10:37:53 AM

141495

Page 1

Item ID: D1048 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 3/15/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 3/22/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: **MAR 09 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1048	Rev A <i>custom</i>								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	1-Cut as per Dwg D1048 Dwg Rev: <u>A custom</u> Prog Rev: <u>A custom</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01							
Quality Control									

PTD

21 20 *02/16/03/14*

21 20 *02/16/03/14*

21
20
 DAS
38
 9-89
MAR 14 2016
 DAS
38
 9-89
APR 04 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>141495</u> Part No. <u>D1048</u> NCR No. <u>16-5721</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date: <u>16-03-23</u>		Step #: <u>100</u>		QTY Effective: <u>21</u>		MRB (QSI042) Approval <u>DAS</u> <u>22</u> <u>16.03.28</u>	
Description Work Order Deviation				Disposition			
Reoccurring issue. Was first brought up on UCR 15-4903, tooling was update but drawing not. PAR15-419 is not completed				Scrap + replace Recut D1048 with predetermine dimension from Marc Bellavance using DEF D1048 "custom" <u>M134158</u>			
				Completed By <u>DL 16/04/04</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>38</u> <u>2-80</u> QC / PAR Coordinator Approval <u>PD</u> <u>APR 04 2016</u>			
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☒ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐			
OTHER: ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 141495

Wednesday, March 09, 2016 10:37:53 AM

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Item ID: D1048

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Clamp

Stop ***NS2***

Start Date: 3/15/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 3/22/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.03

Quality Control

APR 14 2016

MLJ

gm 16/04/14.

MLJ APR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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		OTHER : ☐							

Picklist Print

Wednesday, March 09, 2016 10:37:57 AM

Page 1
1

Work Order ID: 141495

141495

Parent Item: D1048

D1048

Parent Item Name: Clamp

Start Date: 3/15/2016

Required Date: 3/22/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: B02.02.22Re-formatNG
IPP Rev:C Now on Waterjet 06-12-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased			No	100	sf	167.1090	0.018	0.378948			

M304S16GA

304/316 Sheet .063

0216/03/14

Location

MAT019

Loc Qty

167.109

Loc Code

m134067

8.006

m134158

95.103

m134399

64

4
4

DQA: _____ Date: _____



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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														

RELEASED
97/09/02 BC

NOTES:

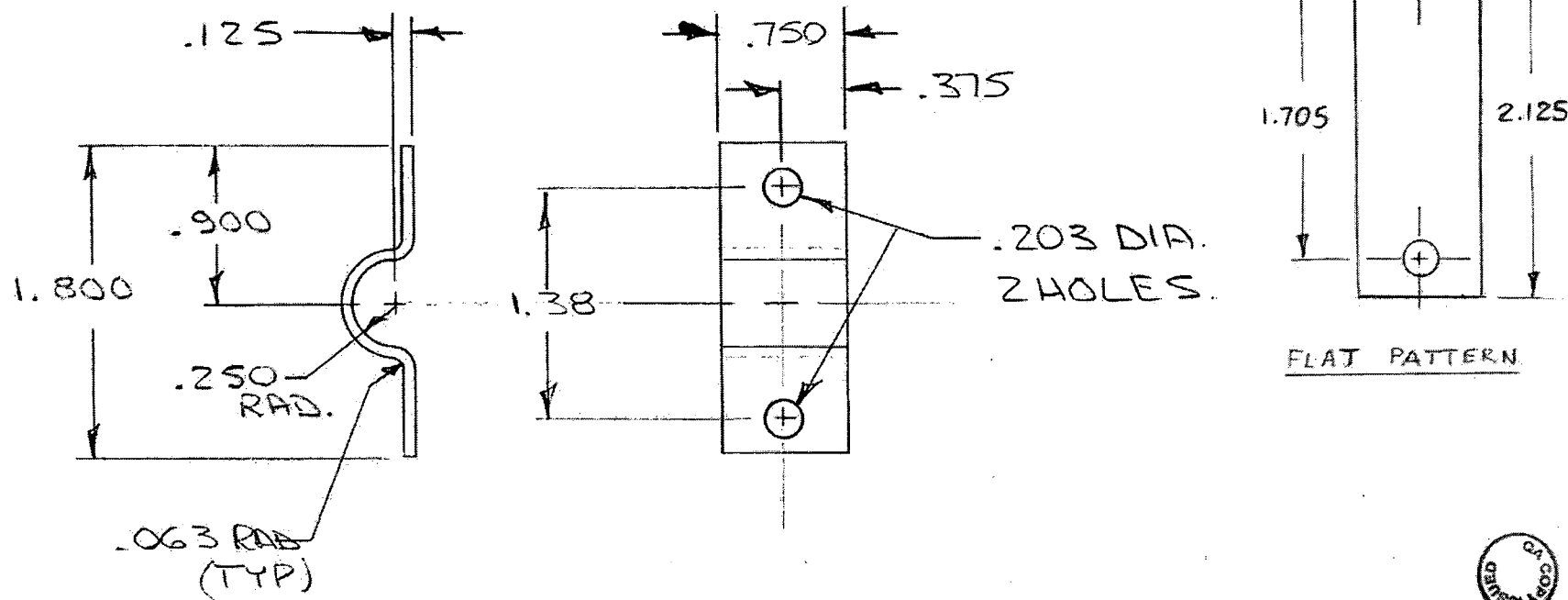
1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020

141495 M/S
1682-08



A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
RF	DRAWN		BASIC CODE	DIA. DASH NO. HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
	APPROVED		D-DIMPLE D-DIGT-NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN BRADLEY	DATE 5/1/97			
DESCRIPTION OF CHANGE		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		TITLE		REV.	
		GENERAL		8-MINSTRONAD 8-MINSTRONAD		CLAMP		A	
		LIMITS				CODE		DWC NO.	
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 7743 5. HOLES PER AND 10287		1. TOLERANCES — .001 & .030 2. ANGLES .001 & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MTC CENTRE LINES .005		D 1048		SCALE 1:1	
		REPORT ALL DISCREPANCIES — DO NOT SCALE				SHT 1 OF 1			

D1048

RELEASED
97/09/02

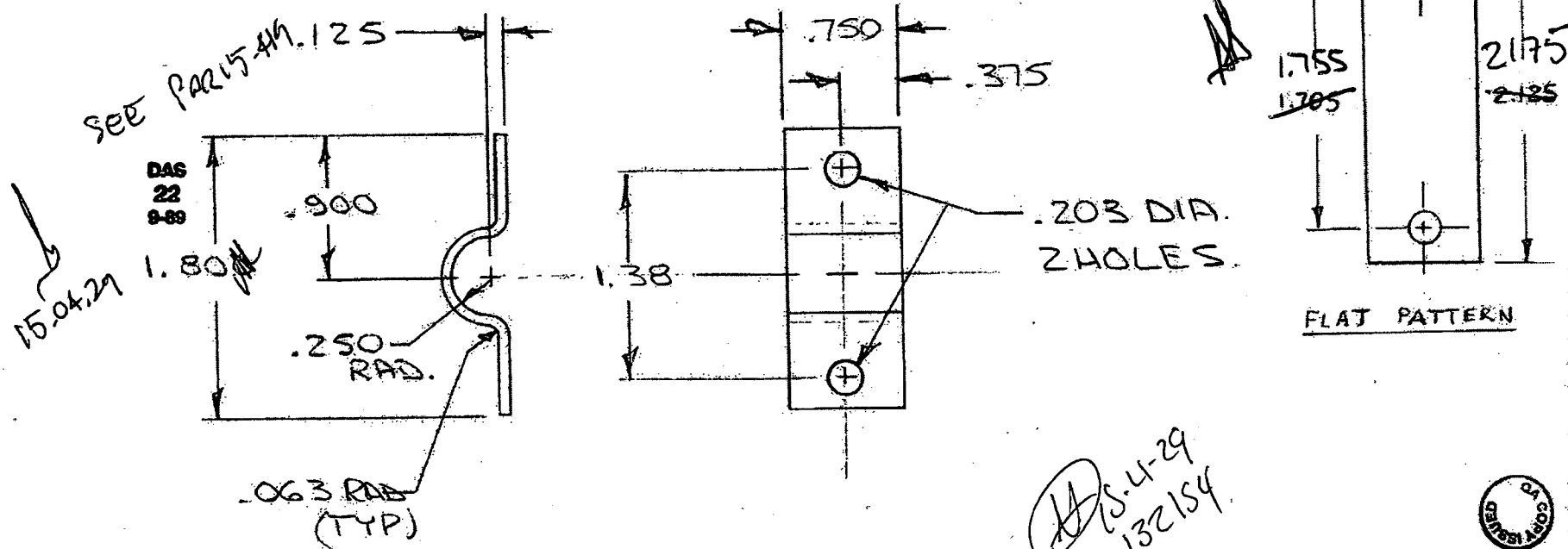
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



15.4-29
132154

A		REVISION	RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
RF		DRAWN	BASIC CODE		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
D		APPROVED	O-DIMPLE O-DIMPLE O-DIMPLE		DRAWN BRADLEY		DATE 1/97		
01.2.05 ADD FLAT PATTERN		DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		DESIGN BRADLEY		TITLE CLAMP		
			GENERAL		STRESS		CODE		
			LIMITS		CHECKED		DOWEL NO. D1048		
			1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES 125 3. NO SHARP EDGES 0.015 MAX 4. THREADS PER INCH - S - 32 5. HOLES PER AND 10387		C/COUNTERSINK		SCALE 1:1		
			1. TOLERANCES - JES 1.000 JES 2.010 2. ANGLES 3. PARAMETER 4. EXCEPT 5. SYMMETRY ABOUT ALL HVC CENTRE LINES 0.015		LONSH DASH NO. WSPOTHELD		SHT OF		
			BASIC CODES		C/COUNTERSINK		REV. A		
			REPORT ALL DISCREPANCIES - DO NOT SCALE		C/COUNTERSINK				

